

Work Order ID 87406

87406

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Item ID: D4035-047

Revision ID:

Item Name: Lid Rib Assembly, Aft (Light)

Start Date: 7/10/12 Start Qty: 1.00

Accept

N900040100

Setup

Start

NS1

Required Date: 8/03/12 Req'd Qty: 1.00

1

Cust Item ID:

Stop

NS2

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/07/19 Tooling:

Date:

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N):

Date: _____

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D4035 | A |

100 Weld per dwg A/R Aluminum rod Batch: M120354

100

Large Fab

Memo

0.00

③ 13-01-30

DAS
09
9-89

Large Fab

1- Cut D4035-7 as per dwg D4035

2- Drill hole using DT9620 and chamfer holes as per dwg D4035

3- remove identification marks and deburr

4- Weld bushing in rib and grind weld flush as per dwg D4035

110

QC10- Inspect visual per QSI004- ground welds

0.00

PL13.2.4

110

QC

Memo

0.00

Quality Control

③

NCR: Yes / No

DQA: Date:

WORK ORDER NON-COMPLIANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | |
|------------------------------|----------------|---------|---|--|--|--|---------------------------------|--------------|----------------------|--------------------|--|
| | | | Rework Scrap Use-as-is Work Order Update | Skid-tube Machining Thermoforming Large Fab | Crosstube Small Fab Finishing Composite | Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier | Engineering Quality Other | | | | |
| Part No. _____ | | | | | | | | | | | |
| NCR No. _____ | | | | | | | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Doc/Data | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | |
| Operator | | | | | | | | | | | |
| Material | | | | | | | | | | | |
| Setup | | | | | | | | | | | |
| Other | | | | | | | | | | | |
| Process | | | | | | | | | | | |
| Supplier | | | | | | | | | | | |
| Training | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | |
| Landing Gear | | | | General | | | | | | | |
| Bending | General | | | Grain | General | | | Ovalized | Pressure/Forced | | |
| Centre Not Concentric to O/S | Bend | General | | | Hardware | General | | | Over/Under tolerance | Temperature/Cure | |
| Cracks | BOM/Route | General | | | Inspection Incomplete | General | | | Part Incorrect | Weld | |
| Crushed/Crimped. | Broken/Damaged | General | | | Instructions Incomplete/Unclear | General | | | Part Lost/Missing | Wrong Stock Pulled | |
| Cuffs | Burrs | General | | | Maintenance | General | | | Part Moved | | |
| Heat Treat | Contamination | General | | | Mislabeled | General | | | Positioned Wrong | | |
| Inspection Strip in Tube | Countersink | General | | | Misread | General | | | Power Loss/Surge | | |
| Ripples in Bend | Cut Too Short | General | | | Offset | General | | | | Other | |
| Torque Waves in Extrusion | Drill Holes | General | | | Out of Calibration | General | | | | | |
| Turning Sequence | Drawing | General | | | Out of Sequence | General | | | | | |
| Wave/Twist in Tube | Finish | General | | | Outside Dimensions | General | | | | | |
| | Folio | General | | | | General | | | | | |

Work Order ID 87406

87406

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| | | | | | | | |
|----------------|-------------------------------|------------|---------------------|------------|---------------|--------------|--------------|
| Item ID: | D4035-047 | Accept | *N900040100* | Setup | Start | *NS1* | |
| Revision ID: | | | | Stop | | *NS2* | |
| Item Name: | Lid Rib Assembly, Aft (Light) | | | | | | |
| Start Date: | 7/10/12 | Start Qty: | 1.00 | *1* | Cust Item ID: | | |
| Required Date: | 8/03/12 | Req'd Qty: | 1.00 | *1* | Customer: | | |
| Reference: | | | | | | | |
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | *NR1* |
| | QC: | Date: | SPC (Y/N): | Date: | Stop | | *NR2* |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Ccode | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|-------------------|--------|---------------|---------------------|---------------|------------------|----------------|
| 120 *120* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 | <i>lpl 13-2-4</i> | | | <i>3</i> | | | |
| 130 *130* Packaging Packaging | Identify as per dwg & Stock Location: <i>WA #5</i> Memo | 0.00 | <i>lpl 13-2-4</i> | | | <i>3</i> | | | |
| 140 *140* QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 | | | | <i>MLS 13-02-04</i> | | | <i>PLB 02M</i> |

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | |
|------------------------------|---------|------|---|--|--|--|---------------------------------|----------------------|--------------------|--|--|
| | | | Rework Scrap Use-as-is Work Order Update | Skid-tube Machining Thermoforming Large Fab | Crosstube Small Fab Finishing Composite | Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier | Engineering Quality Other | | | | |
| Part No. _____ | | | | | | | | | | | |
| NCR No. _____ | | | | | | | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Doc/Data | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | |
| Operator | | | | | | | | | | | |
| Material | | | | | | | | | | | |
| Setup | | | | | | | | | | | |
| Other | | | | | | | | | | | |
| Process | | | | | | | | | | | |
| Supplier | | | | | | | | | | | |
| Training | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | |
| Landing Gear | | | | General | | | | | | | |
| Bending | General | | | Bend | General | | | Ovalized | Pressure/Forced | | |
| Centre Not Concentric to O/S | | | | BOM/Route | | | | Over/Under tolerance | Temperature/Cure | | |
| Cracks | | | | Broken/Damaged | | | | Part Incorrect | Weld | | |
| Crushed/Crimped | | | | Burrs | | | | Part Lost/Missing | Wrong Stock Pulled | | |
| Cuffs | | | | Contamination | | | | Part Moved | | | |
| Heat Treat | | | | Countersink | | | | Positioned Wrong | | | |
| Inspection Strip in Tube | | | | Cut Too Short | | | | Power Loss/Surge | | | |
| Ripples in Bend | | | | Drill Holes | | | | Other | | | |
| Torque Waves in Extrusion | | | | Drawing | | | | | | | |
| Turning Sequence | | | | Finish | | | | | | | |
| Wave/Twist in Tube | | | | Folio | | | | | | | |
| | | | | Grain | | | | | | | |
| | | | | Hardware | | | | | | | |
| | | | | Inspection Incomplete | | | | | | | |
| | | | | Instructions Incomplete/Unclear | | | | | | | |
| | | | | Maintenance | | | | | | | |
| | | | | Mislabeled | | | | | | | |
| | | | | Misread | | | | | | | |
| | | | | Offset | | | | | | | |
| | | | | Out of Calibration | | | | | | | |
| | | | | Out of Sequence | | | | | | | |
| | | | | Outside Dimensions | | | | | | | |

Picklist Print

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Page 1

| | | | | | |
|--------------------------|-------------------------------|--------------------|---------|-----------------------|---------|
| Work Order ID: | 87406 | Start Date: | 7/10/12 | Required Date: | 8/03/12 |
| Parent Item: | D4035-047 | Start Qty: | 1.00 | Required Qty: | 1.00 |
| Parent Item Name: | Lid Rib Assembly, Aft (Light) | | | | |

Comments: IPP RevA: new issue DD 10.01.25 verified by:EC
verified by:EC IPP Rev:B as per dwg revA 10.03.15

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| D4035-11 Bushing | | Manufactured | No | | | 100 | Each | 16.0000 | 2 | 2 | | 13-01-30 | PD |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | WA005 | | 16 | | | | | | 5888890 | |
| | | | | 59749 | | 16 | | | | | | | |
| M6061T6TS0.750W.062 6061-T6 SQ Tube .75 x .75 x .062W | | Purchased | No | | | 100 | f | 359.5789 | 1.875 | 1.9736842 | | 13-01-30 | PD |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | MAT013 | | 359.5789 | | | | | | | |
| | | | | 122200 | | 359.5789 | | | | | | 2,765.919 | |

NCR: Yes / No

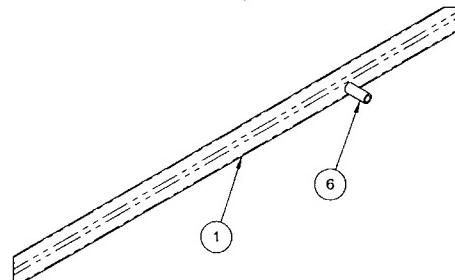
DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

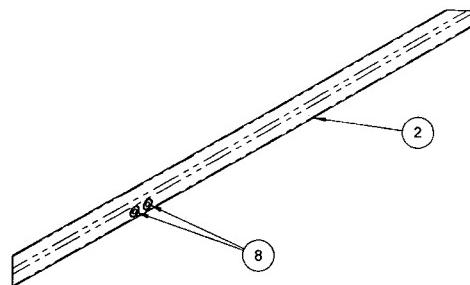
QA Closed: _____ Date: _____

| Work Order: _____ | | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | | | | | | | | | | |
|--|------|--|--------------------------------|---|------------------------------------|------------------------------------|--|---|------------------------------------|------------------------------------|------------------------------------|--|------------------------------------|---|--|---|--------------------------------------|----------------------------------|--------------------------------|
| | | Rework <input type="checkbox"/> | Scrap <input type="checkbox"/> | Use-as-is <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Machining <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Finishing <input type="checkbox"/> | Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> | Quality <input type="checkbox"/> | Other <input type="checkbox"/> |
| Part No. _____ | | Work Order Update <input type="checkbox"/> | | | | | | | | | | | | | | | | | |
| NCR No. _____ | | | | | | | | | | | | | | | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | | Initial Chief Eng | Action Description | | | Sign & Date | Verification | QC Inspector | | | | | | | |
| Doc/Data | | | | | | | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | | | | | | |
| Setup | | | | | | | | | | | | | | | | | | | |
| Other | | | | | | | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled | | | |
| | | | | | | | | | | | | | | | | <input type="checkbox"/> Other | | | |
| | | | | | | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | | | | | |

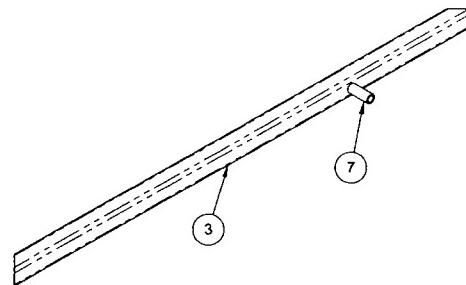
| ITEM | QTY -041 | QTY -043 | QTY -045 | QTY -047 | P/N | DESCRIPTION |
|------|-------------|-------------|-------------|-------------|-----------|---------------------------|
| D | X | | | | D4035-041 | LID RIB ASSY, FWD |
| | | X | | | D4035-043 | LID RIB ASSY, AFT |
| | | | X | | D4035-045 | LID RIB ASSY, FWD (LIGHT) |
| | | | | X | D4035-047 | LID RIB ASSY, AFT (LIGHT) |
| 1 | 1 | | | | D4035-1 | RIB |
| 2 | | 1 | | | D4035-3 | RIB |
| 3 | | | 1 | | D4035-5 | RIB |
| 4 | | | | 1 | D4035-7 | RIB |
| 5 | | | | 2 | D4035-11 | BUSHING |
| 6 | 1 | | | | D2327-3 | SPACER BUSHING |
| 7 | | | 1 | | D2953-175 | SPACER |
| 8 | | 2 | | | D4021-9 | BUSHING |



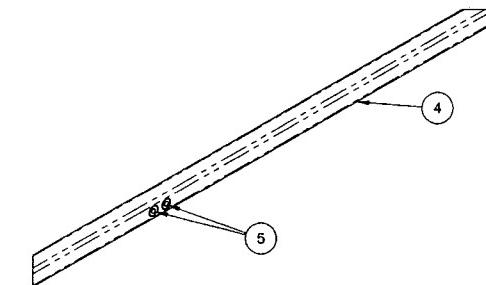
D4035-041 BASKET LID RIB ASSY, FWD



D4035-043 BASKET LID RIB ASSY, AFT



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)



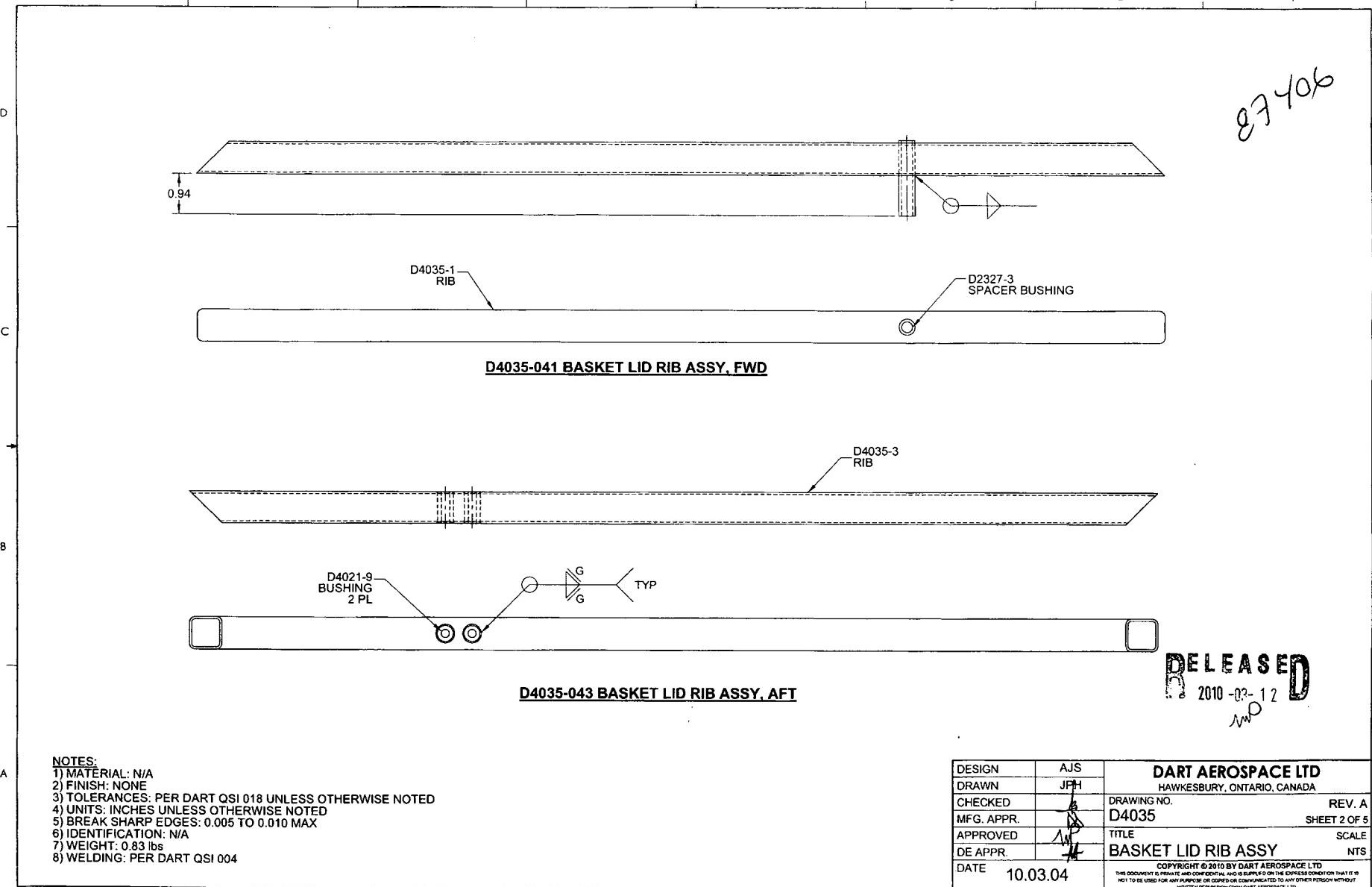
D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 87406 MLJ

12/07/19

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2010-03-12
MW

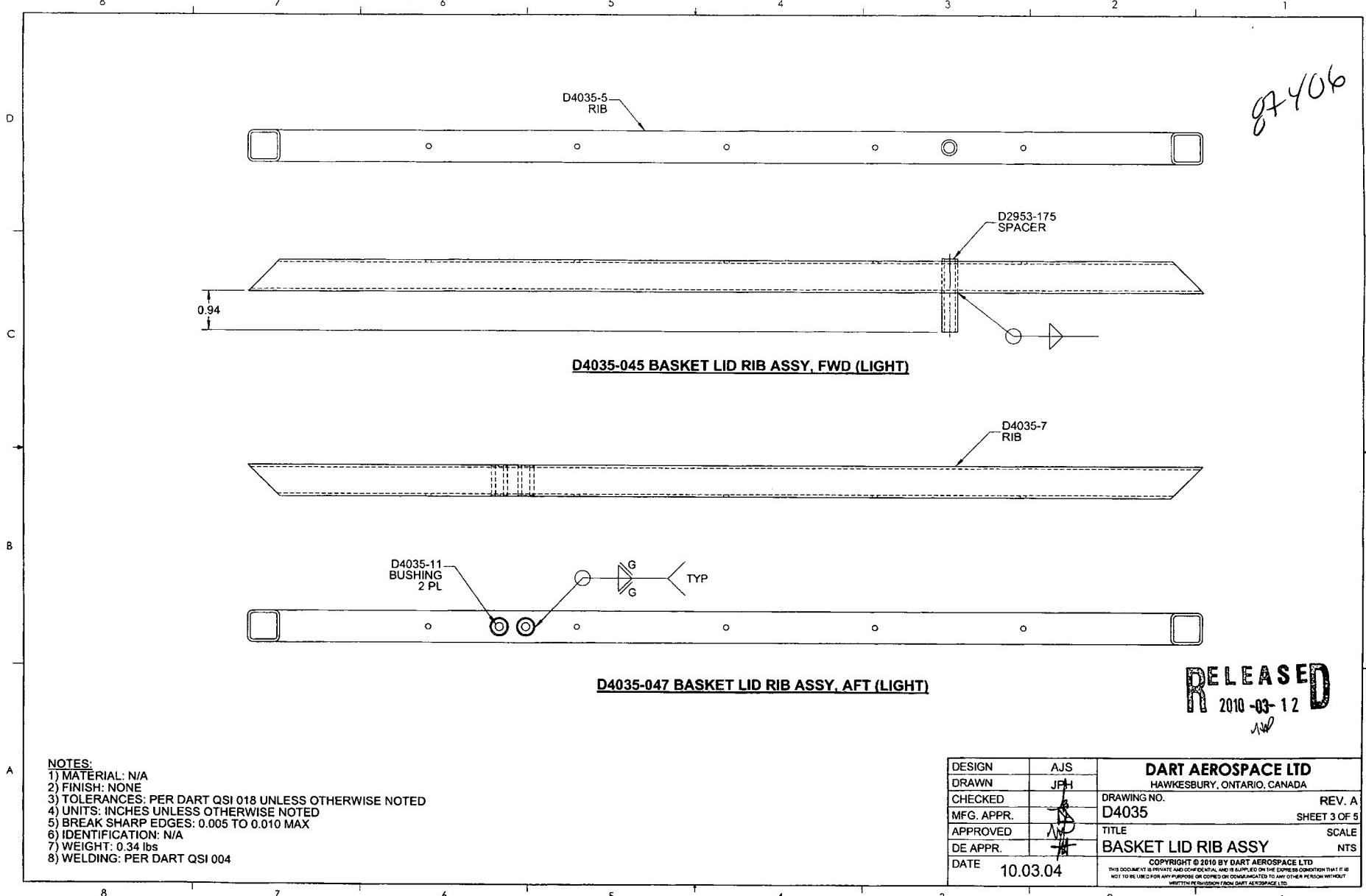
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| A | NEW ISSUE | JPH | 10.03.04 |
| REV. | DESCRIPTION | | BY DATE |
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | JPH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D4035 | SHEET 1 OF 5 |
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| DE APPR. | | BASKET LID RIB ASSY | NTS |
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| APPROVED | <i>[Signature]</i> | D4035 | |
| DE APPR. | <i>[Signature]</i> | SHEET 2 OF 5 | |
| DATE | 10.03.04 | TITLE | |
| | | SCALE | |
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2010-03-12
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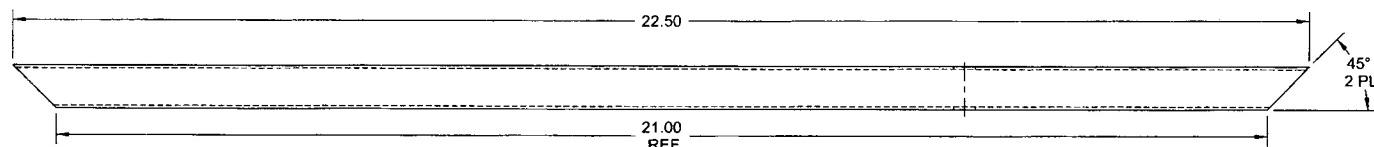
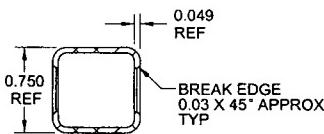
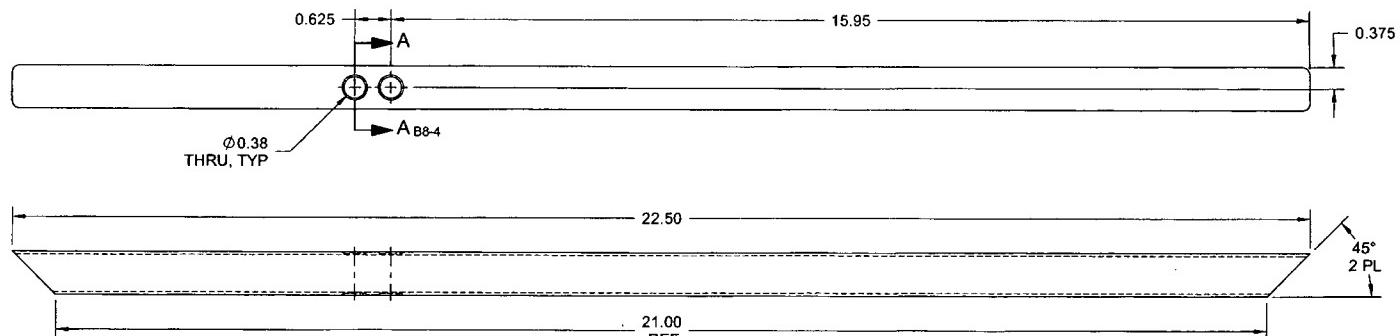
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| APPROVED | | SHEET 3 OF 5 | |
| DE APPR. | | TITLE | |
| DATE | 10.03.04 | SCALE | |
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87406

8 7 6 5 4 3 2 1

**D4035-1 RIB****SECTION A-A B5-4****D4035-3 RIB**

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2010-03-12
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NOTES:

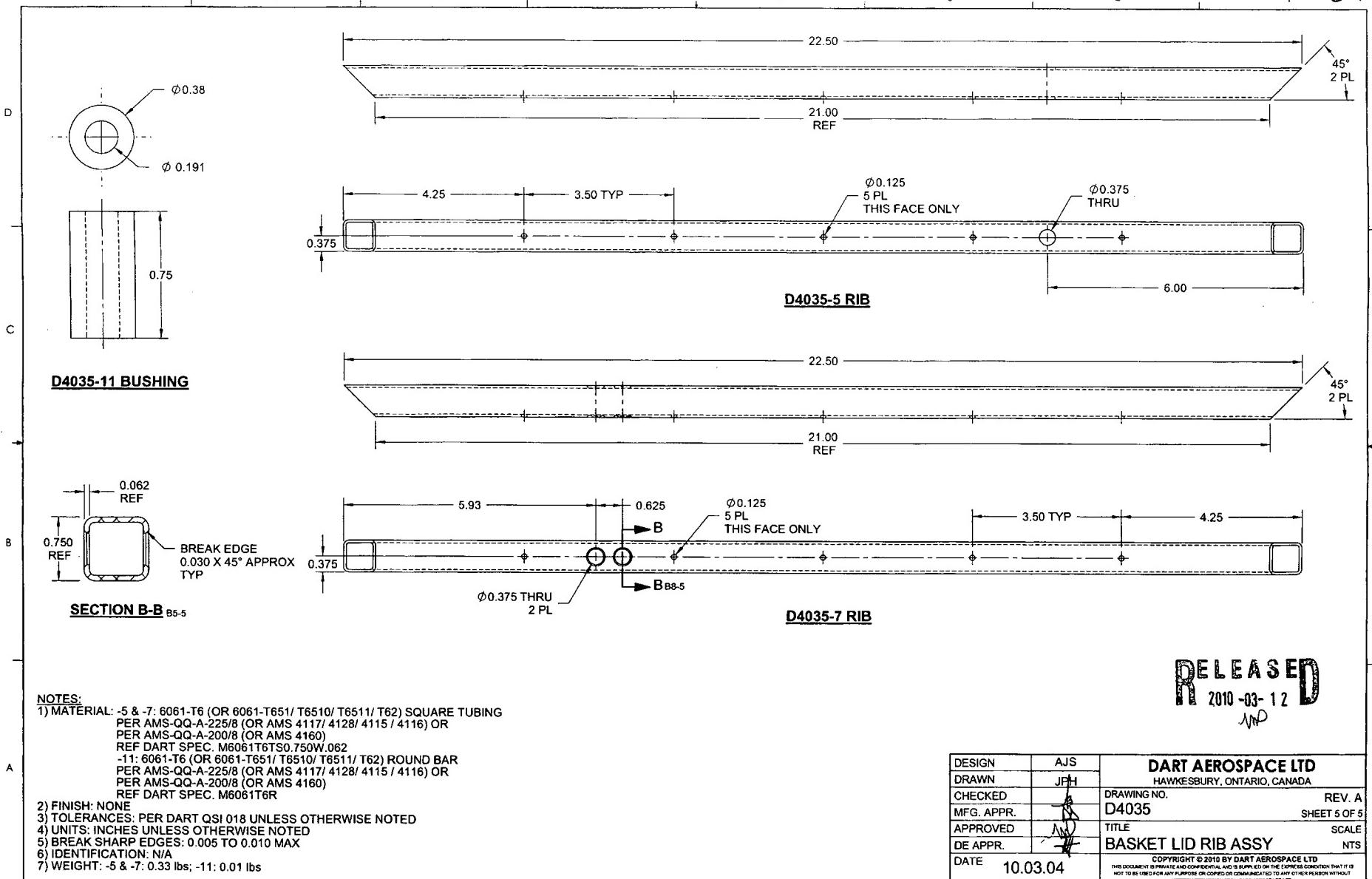
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
PER ASTM A554/A269 MILL FINISH
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.80 lbs

8 7 6 5 4 3 2 1

| | | | |
|------------|----------|-----------------------------|---------------------|
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| DRAWN | JPH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | |
| MFG. APPR. | | REV. A | D4035 |
| APPROVED | | SHEET 4 OF 5 | |
| DE APPR. | | TITLE | BASKET LID RIB ASSY |
| DATE | 10.03.04 | SCALE | NTS |

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| CHECKED | | DRAWING NO. | |
| MFG. APPR. | | D4035 | |
| APPROVED | | REV. A | |
| DE APPR. | | SHEET 5 OF 5 | |
| DATE | 10.03.04 | TITLE | |
| | | BASKET LID RIB ASSY | |
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